

Date: Tuesday, 12/5/2006 1:49:36 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CLAMP	
Job Number	: 29835				
Estimate Number	: 10623				
P.O. Number	: N/A		Part Number	: D2947	
This Issue	: 12/5/2006	S.O. No. : N/A	Drawing Number	: D2947 REV B A1 06.12.05	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B A1	
Previous Run	: 27877		Material	: N/A	
Written By	:		Due Date	: 12/22/2006	
Checked & Approved By	:		Qty:	100	Um: Each
Comment	: Est: A 00.01.14 New issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
		 Comment: Qty.: 0.0504 sf(s)/Unit Total : 5.0400 sf(s) 304/316 .063 Sheet batch: M101873 ml 06 12 12 (100)
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2947 Dwg Rev: A1 Prog Rev: A1 ml 06 12 12 (100) 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE (100)
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK (100)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr any rough edges SAD 06.12.18 (100) 2- Bend as per Dwg D2947 SAD Issue P.O for forming 3077 GFI C207102109 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/02/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 1:49:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29835

Part Number: D2947

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



07/02/28



Comment: INSPECT WORK TO CURRENT STEP

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SAD

07/02/28

100

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB

07/02/28

100

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/28

PO

Job Completion



07/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

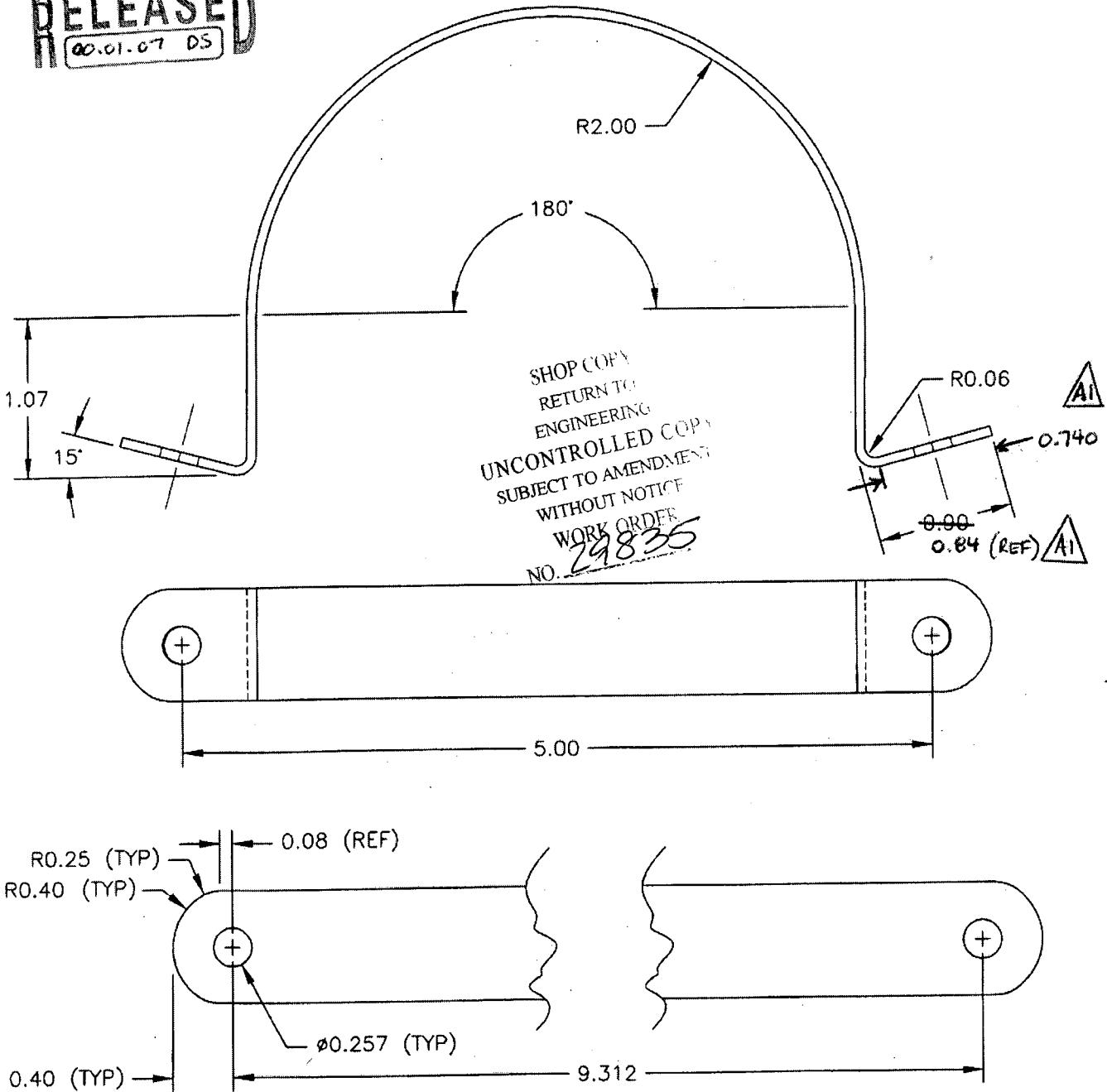
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART3 COPY
SHEET

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2947	SHEET 1 OF 1
DATE	TITLE	CLAMP	SCALE
00.01.06	A	00.01.06	1:1
	NEW ISSUE		

RELEASED
00.01.07 DSD2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES

DART AEROSPACE LTD

Work Order: Q9835

Description: Clamp

Part Number: D2947

Inspection Dwg: DSG47 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X

X First Article X

Measured by: M.M.
Date: 08.12.12

Audited by:	
Date:	06/12/14

Prototype Approval: MM

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **5** OUR JOB NO **J0157554** SHIPPING MEMO **0358106**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	350 PCS	PO00003077	D2947	A	CLAMP	A
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
SST 304 / 316		SUPPLIED BY DART AEROSPACE			P.O # 3077	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **20 FEBRUARY 2007**

G.F.I. Q.C. REP.

B. Samiec

